

Work Order ID 55727

January 29, 2010 8:22:54 AM



Page 1

Item ID: D3436-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 1/28/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]* Date: *10-1-29*

Tooling:

Date:

Stop



QC: Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn as per Folio FA526 and Dwg D3436 ☐ Deburr

0.00

SA 10/02/01

0.00

30 0

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

SA 10/02/01

0.00

30 0

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

M.A 10/02/01

0.00

30 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: CON

0.00



Packaging

Memo

0.00

Packaging

10/10/13 (30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04 MF10-2-3

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NOTE: Date & initial all entries

2.3

Picklist Print

Page 1

January 29, 2010 8:22:58 AM

Work Order ID: 55727



Parent Item: D3436-5



Parent Item Name: Bushing

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP A 05.05.11 New issue KJ/JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NT0.373W.049		Purchased	No			100	f	21.7300	2.2800			
4130 RD tube .373 x .049W												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

MAT

111329

21.73

21.73

3.2551 10/02/01

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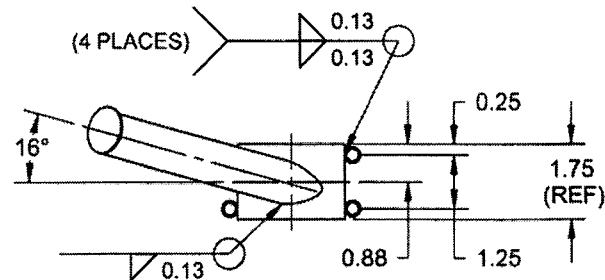
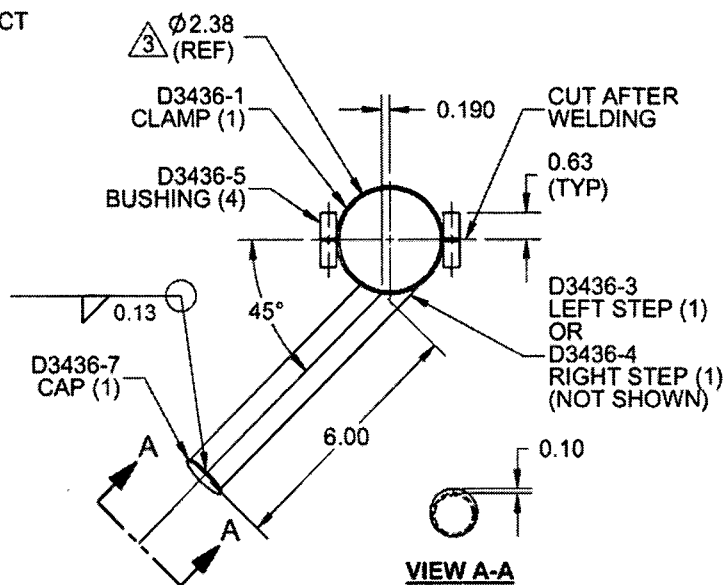
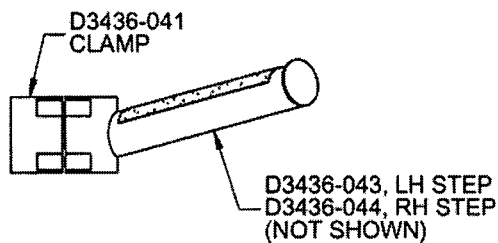
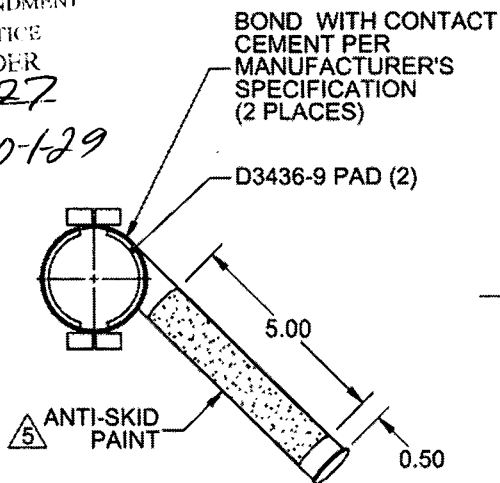
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NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	

SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **55727****10-129****WELDING****NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED**05.05.27**

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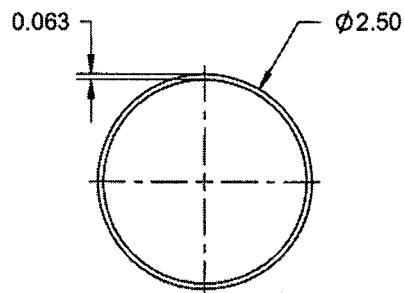
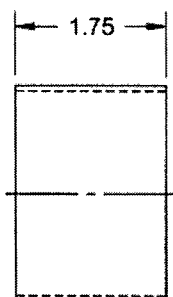
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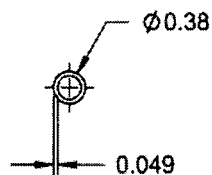
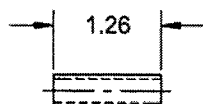
w/0 55727

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

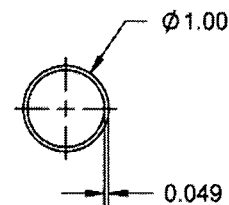
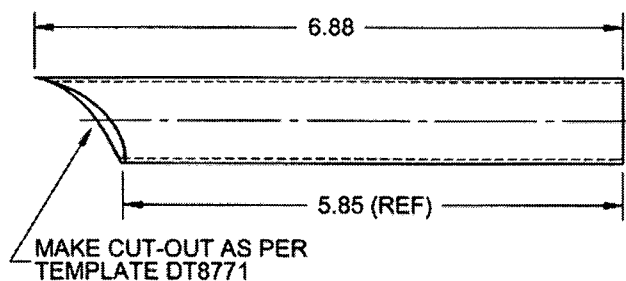
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W/O 55727

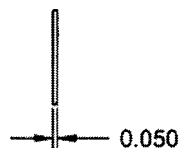
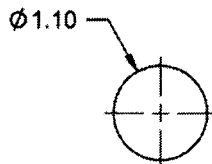
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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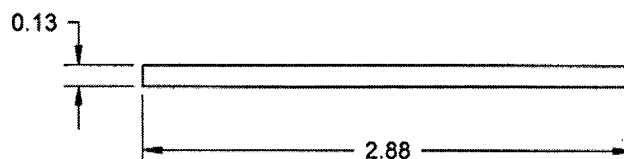
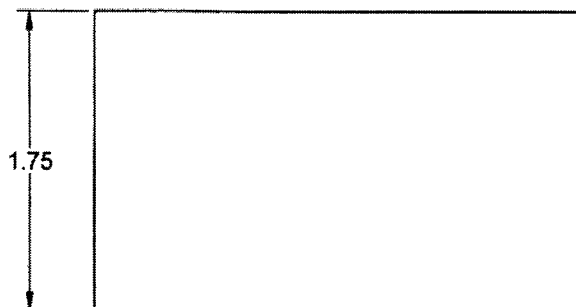
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w/o 55727

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED
05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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